

Work Order ID 96317

96317

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Monday, February 11, 2013 12:57:53 PM

Item ID: D412-666-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gross Weight Towing

Start Date: 1/23/2013 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/24/2013 Req'd Qty: 1.00 *1*

Customer: CU-DAR001

Reference: RMA RA111468

Approvals: Process Plan: *MMK*

Date: 13-2-11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-666

Rev C1

100

0.00

100

QC

Quality Control

Memo

INSPECT RA 111468 D412-666-011 X 1 B#87262

KIT IS GOOD EXCEPT FOR D2888 THAT NEEDS TO BE RE-POWDER COATED

110

0.00

110

HandFinish

Hand Finishing

Memo

STRIP COMPLETELY D2888 AND RE-ALODINE

120

QC7-Inspect Chemical Conversion Coat

0.00

120

QC

Quality Control

Memo

0.00

ML 5 13-02-19

1 2/13 13-2-12

1 13-2-13



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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/23/2013 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/24/2013 **Req'd Qty:** 1.00 *** 1 ***

Customer: CU-DAR001

Reference: RMA RA111468

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Insp. Stamp

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Alum

0.00

130

White Gloss (Ref: 42.5.1) per
M/23383

0.00

Powdercoat

Memo

Powder Coating

START TIME: 10:05
OVEN TEMPERATURE: 370°
FINISH TIME: 10:35

140

QC3- Inspect Part Finish

0.00

140

DAS
15
1-62
13.2.19

QC

Memo

0.00

Quality Control

145

QC4- 100% Inspect kits for completeness

0.00

145

Shw
B2 10

QC

Memo

0.00

Quality Control

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Required Date: 1/24/2013 Req'd Qty: 1.00 ***1***

Customer: CU-DAR001

Reference: RMA RA111468

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

(10)

13/2/19 (DAS 06)

MLJ 13-02-19

13-02-19

Picklist Print

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Work Order ID: 96317

Parent Item: D412-666-011

Start Date: 1/23/2013

Required Date: 1/24/2013

Parent Item Name: Gross Weight Towing

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B Added GHG 002 NG 02-03-06
IPP Rev:C As per Rev C JLM 07-09-07 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-666-011 Gross Weight Towing		Manufactured	No				Each	2.0000		1			

Location

Loc Qty

Loc Code

FG

1

91868

1

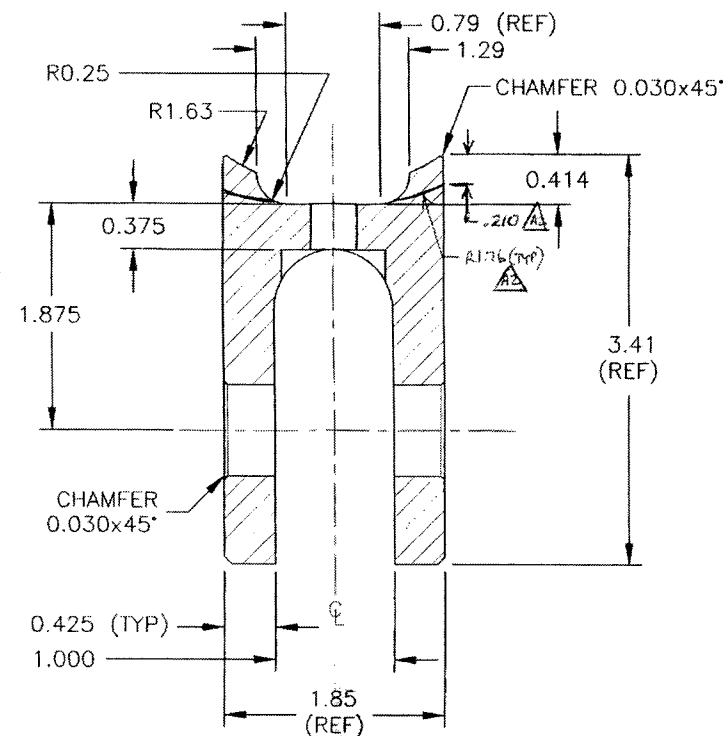
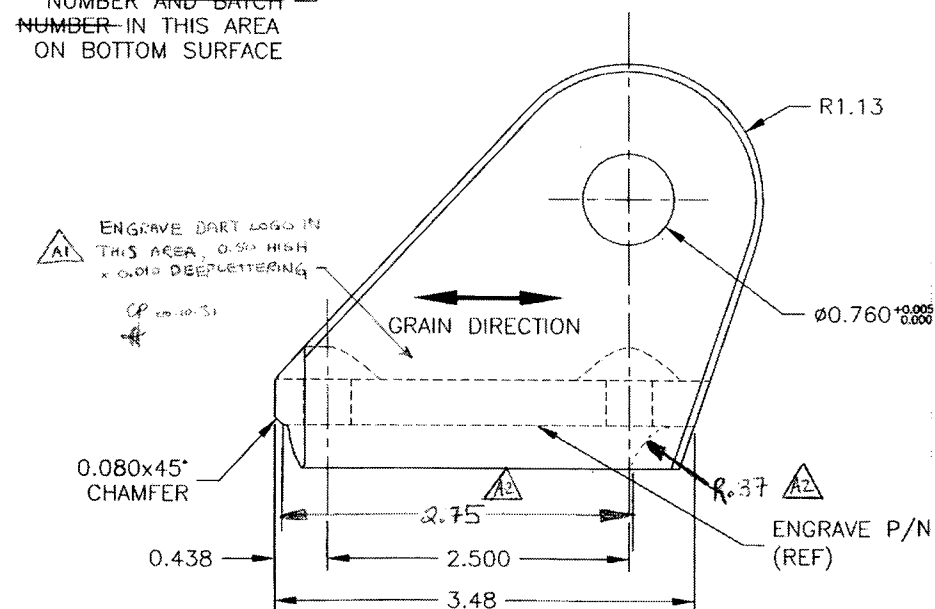
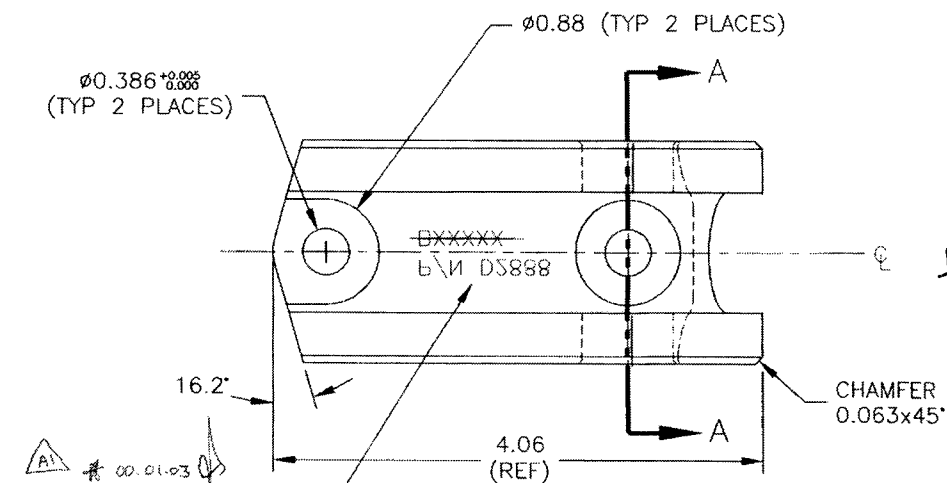
FG120

1

91352

1

1 X 87262
mf
12-2-19



SECTION A-A
SCALE 1:1

RELEASED
99.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Solder Clearance	Per NCR 784
A1	00.10.31	Update Engineering	0010.31

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY CP	DART DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED KE	DRAWING NO. D2888
DATE	99.06.21	TITLE LUG
		REV. A SHEET 1 OF 1 SCALE 1:1

RA 111468

D412-783-011 B84629 D212-666-011 B87262

Received @ Dart January 11th, 2013
Inspected @ Dart January 17th, 2013

Customer: ROTOCRAFT SUPPORT INC
Customer Contact: VERONICA LAZANO
Shipped from: SAN DIEGO CA, USA

Instructions for RA 111468

- **D412-783-011 B84629 CHG004**
 - Due to improper packaging by customer crank assembly needs to be RE-FINISHED (re powder coated) see pics
 - Disassemble complete and strip all powder coated parts
 - Re powder coat as per QSI005
 - While doing this re swage handle to tight assembly and insure no complaints from future customers on stripping
 - Re assemble and re adjust the torque (new calibration sheet will be required)
 - Kit is complete
 - New work order needed
 - Needs new paper work and labels
- **D412-666-011 B87262 CHG 004**
 - Due to improper packaging by D2888 needs to be RE-FINISHED (re powder coated)
 - Strip D2888 and re alodine and re powder coat as per QSI005
 - Kit is complete
 - Needs new paper work and labels
 - Needs work order for all rework
 - Needs new BATCH #

Time Estimate = 10 HOURS

Departments Required: Stores, Large Fab, Finishing, & Dan Stow

Pictures Attached = YES

QTY INSPECTED = x1 D412-666-011 B87292
x1 D412-783-011 B84629

**THIS INSTRUCTION SHEET MUST BE
ATTACHED TO THE RESTOCKING
WORK ORDER AT ALL TIMES!!!!**

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	